


Date: Monday, 12/11/2007 9:42:49 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CONSOLE BRACKET (407I)
<b>Job Number</b> :	35492		
<b>Estimate Number</b> :	11008		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D2608
<b>This Issue</b> :	12/11/2007	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2608 REV .A1
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	35492	<b>Drawing Revision</b> :	A 1
	<b>Type</b> :	<b>Material</b> :	N/A
	MACHINED PARTS	<b>Due Date</b> :	05/12/2007
<b>Written By</b> :			<b>Qty:</b>  <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est. E 02.06.05 Added alodine finish TSR 1290 NG Est Rev F Added Rev.A 1 07-11-01 DD Est Rev:G now water jet 07-11-12 DD verified by EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S040	2024-T3 .040 sheet
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H705



**Comment:** Qty.: 0.0941 sf(s)/Unit Total : 0.0941 sf(s)  
 2024-T3 .040 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040) Batch M 103321 HB 07-11-13

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2608 (Grain along 9.03, offset 10 deg)  
 Dwg Rev: A1  
 Prog Rev: A1 HB 07-11-13  
 2-Deburr if necessary HB 07-11-13

05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-11-13



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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HB 07-11-13 (5)



**Comment:** SECOND CHECK

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET (407I)

Job Number: 35492

Part Number: D2608

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D2608

SP 07/12/03 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9/12/06 (45)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

07-12-07

(X5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/12/07 (5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 38

7/12/07 SP (5X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



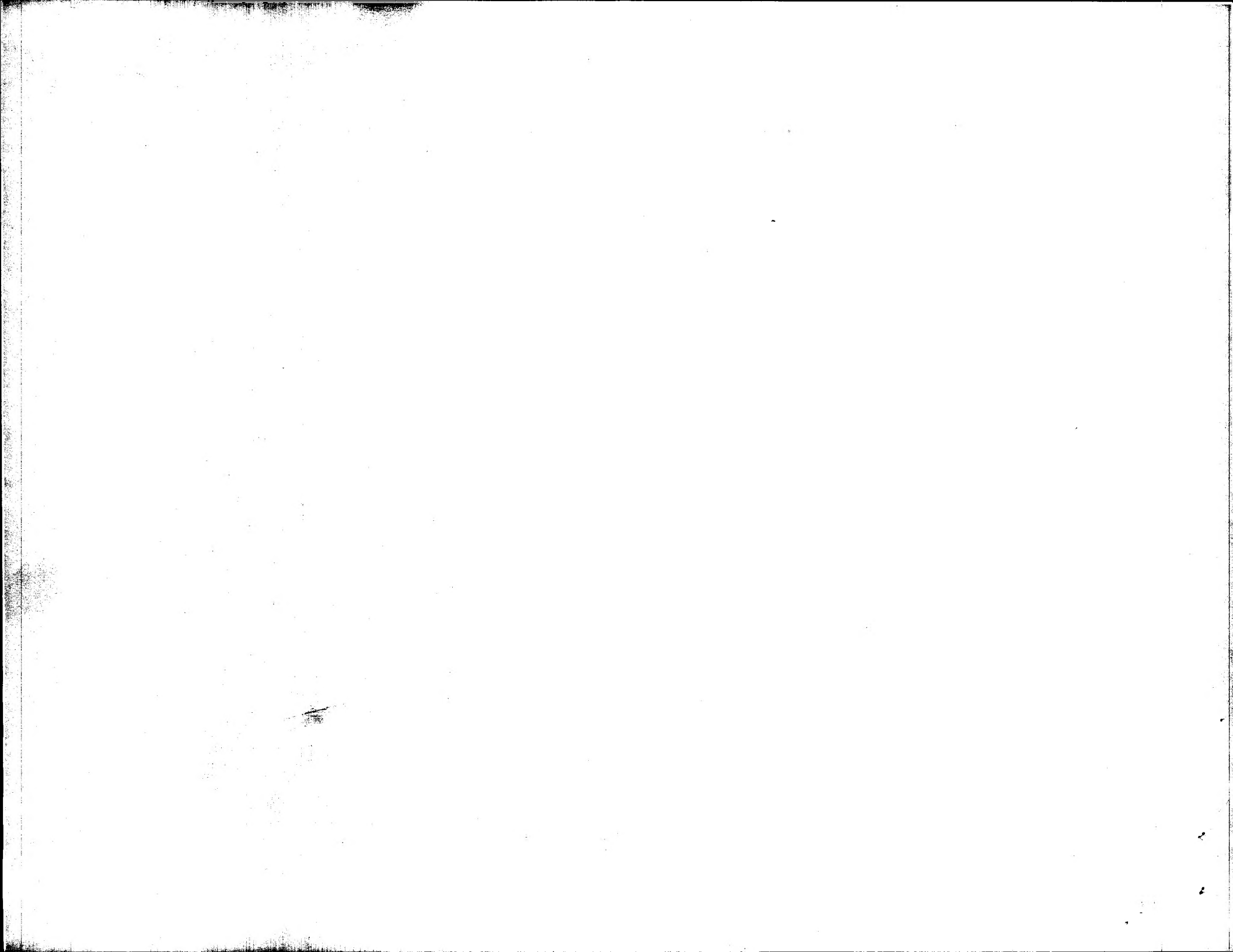
Comment: FINAL INSPECTION/W/O RELEASE

2012/11 (5)

Job Completion



mi 2007/12/11 PL



Date: Wednesday, 10/31/2007 3:26:41 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE BRACKET (407I)
Job Number	: 35492		
Estimate Number	: 11008		
P.O. Number	:	Part Number	: D2608
This Issue	: 10/31/2007 S.O. No. :	Drawing Number	: D2608 REV A I
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A I
Previous Run	:	Material	:
Written By	:	Due Date	: 12/5/2007 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est. E 02.06.05 Added alodine finish TSR 1290 NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0941 sf(s)/Unit Total : 1.8816 sf(s)  
2024-T3 .040 sheet  
Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
(M2024T3S.040) Batch \_\_\_\_\_

*W. Heyes*

2.0	SHEAR	SHEAR
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Comment: SHEAR  
Cut Blanks 1.891 X 9.03 (Grain along 9.03 offset 10°)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine per folio D2607

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Deburr  
Form as per Dwg D2608

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET (407I)

Job Number: 35492

Part Number: D2608

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

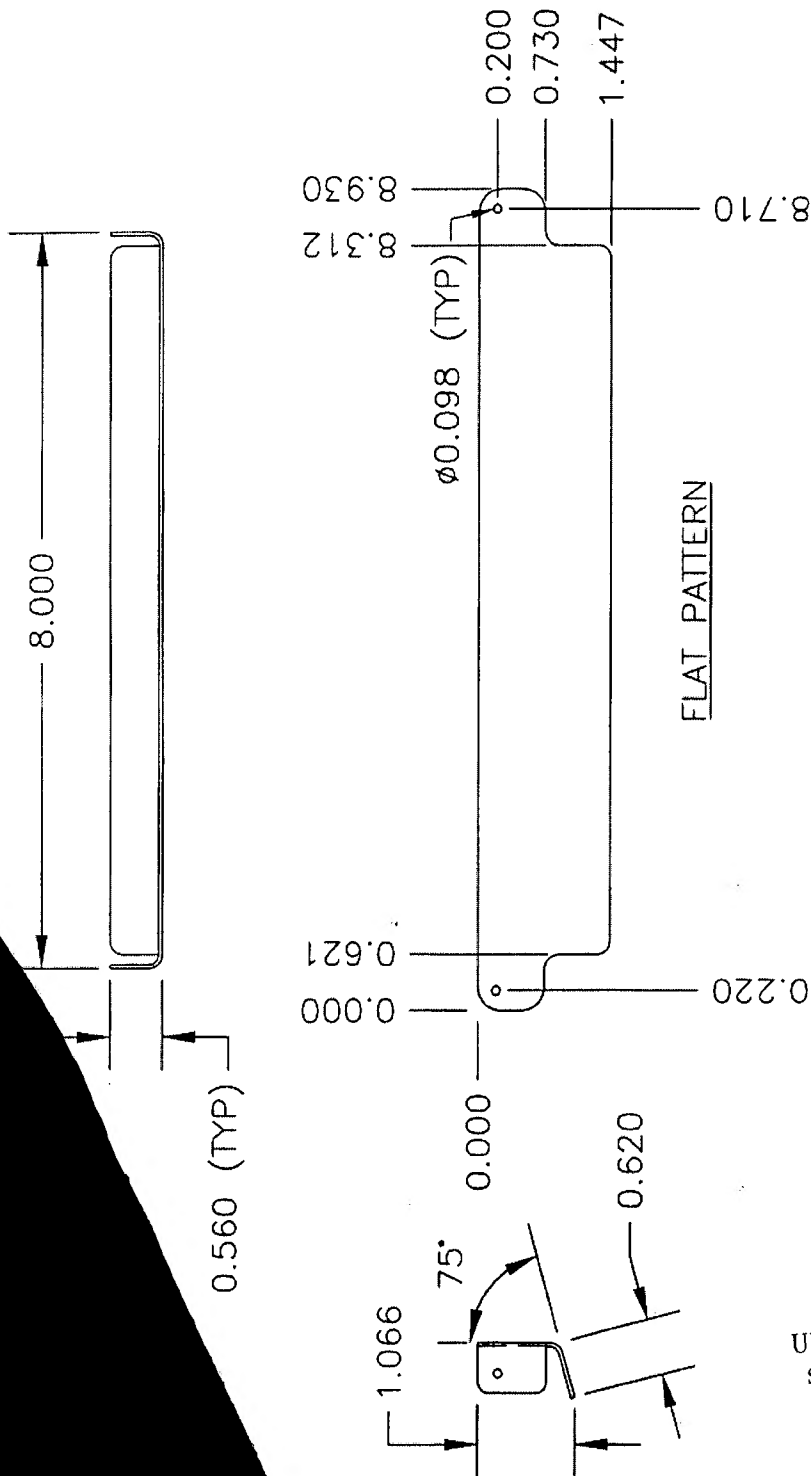
**NOTE:** Date & initial all entries



DESIGN BW	DRAWN BY BW	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED A	DRAWING NO. D2608	REV. A SHEET 1 OF 1
DATE 97.10.23		TITLE CONSOLE BRACKET	SCALE 1:2
A	97.10.23	D2608 WAS D206-547-25	
AI	02.06.04	ADD FINISH	

RELEASED  
97.11.04 KE

TSR A421



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35492

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
PROFILE CONTROLLED BY FOLIO H2608  
BEND RADIUS 0.093  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI Q5 4.1 AI



